Work Order II September-05-14 2:2			*12	4026*							Page 1
Revision ID: Item Name: Plug	92-1		Accept	*N900	104 0	10	N *	Setup	Start Stop	***	IS1*
Start Date: 9/05/3 Required Date: 9/05/3 Reference:	€-3. ==0.00	1/1/		Cust Item Customer:					P	*/\	IS2*
QC:	cess Plan: _MLJ	Date: 14-09-05	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^I\	IR1* IR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp.
Draw Nbr	Revision Nbr					Couc	Qij	Qiy		Number	Stamp
D3492	Е										
*100 *100 Hardinge Hardinge CNC Lathe Small	Hardinge CNC LATHE S Memo 1-Turn as per Dwg Rev:	Folio FA633 & Dwo D340	0.00 0.00 2			1,	120		8		0AS 37 9-89 14.04.07
110 *1 1 	Folio Rev: #		0.00				120	<u> </u>	<u> </u>		DAS 37 9-89 /4.09.0
*120 *120* OC	QC8- Inspect parts - secon Memo	d check	0.00				120	Ø			DAS 40 9-89
¹²⁰ *1 <i>2</i> ∩*		d check					120	Ø			

DQA:			Date:										"DART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		ork Order up	date only	AEROSPACE
QA Closed.			Dute.			DISPOSITION			<u> </u>		PARTMENT		
Work Ord	er: ˌ					,	,		—		1	_	,
Part	No.					Rework Scrap			Skid-tube	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR	No.					Use-as-is Suspected Unapproved		inern	noforming Large Fab	Finishing Composite	Recystor	e/Packaging Supplier	- Other
Root					Desci	ription of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty.	,	or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling					ļ								
Handling/Pre													
Material]								1	Į.	
Operator	2	43										•	
Offset/Setup		15											
Process	ě,	j. e											
Supplier							1						
Training										,			
Transport							1						
Unapproved	8 1.5	1									<u> </u>		
	37						FA	ULT CA	TEGORY				
Land	ing (Gear				General		_				_	_
		Bending				Bend		Folio/I	Program		Outside Dim	ensions	Pressure/Forced
		Centre N	ot Concei	ntric		BOM/Route		Grain		<u> </u>	Over/Under	tolerance	_Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci _	Temperature/Cure
		Crimp/Kii	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
٠,		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear	Part Moved	<u></u>	Wrong Stock Pulled
C8		Crushing				Countersink		Misali	gned/off center	L	Positioned \	Wrong	~~
1540		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set				<u> </u>	
		Turning S				Finish		Out of	Calibration				
1		Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence				

Work Ord				*124	4026*				77 ° 2		Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	D3492-1 Plug 9/05/14 : 9/05/14	Start Qty: 120.00 Req'd Qty: 120.00	*12(*12(*N900 Cust Item Customer:		10	N *	Setup	Start Stop	*NS1* *NS2*
Approvals:	Process P QC:	lan:	Date:	Tooling:	D :	ate:			Run	Start	*NR1*
Sequence ID/ Work Center II 150 *150* HandFinish Hand Finishing		Operation Description Chemical Conversion Coat Memo	Date:	SPC (Y/N): Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accep Qty	ot Rej Qty		*NR2* Reject Insp. Number Stamp
160 *160* Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) pe Memo (Flat End Only) START TIME: OVEN TEMPE FINISH TIME:	8.50.	0.00				126	<u></u>	<i>j</i> 4.	19-16. 88.
170 *17 QC Quality Control		QC3- Inspect Part Finish Memo	. , ,	0.00				121	8	(D 14/09/16

DQA:			Date:							·			DART
						WORK ORDER NON-	·CC	NFOF	RMANCE / UI		ork Order up	data only	AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only	· · · · · · · · · · · · · · · · · · ·
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	:
WORK OT GR	٠					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite]	Supplier	
				,									
Root					Desc	ription of work order update		nitial		ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design			:										
Doc/Data													
Equip/Tooling													
Handling/Pre	Ш												
Material	Щ												
Operator	Н						İ						
Offset/Setup	Н										ł		
Process		!											
Supplier	<u> </u>				Ì								
Training Transport	Н	!											
Unapproved	\vdash												
опаррточеа			1		l		FA	ULT CAT	EGORY				
Landi	ng (Gear				General							
	Ĺ	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect] Hardwa	ire		Part Incorre	ci _	Temperature/Cure
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/l	Unclear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V		¬
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea					
		Marks/Cl	natter		L.	Drill Holes	_	Off-set					
		Turning S	Sequence			Finish	L	4	Calibration				
		Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence				

Work Ord		=			*124	1026*							Page 3
Item ID: Revision ID: Item Name:	D3492-1 Plug			A	ccept	*N900	0040	110	N *	Setup	Start Stop		S1*
Start Date: Required Date: Reference:	9/05/14 9/05/14	Start Qty: 120.00 Req'd Qty: 120.00		*120* *120*		Cust Item Customer:					ous _F	*101:	S2*
Approvals:	Process Pl	lan:	Date:		Fooling:		ate:			Run	Start Stop		₹1 *
Sequence ID/ Work Center II)	Operation Description Identify as per dwg & Stock	Location	. PP-00(Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	ot Rej Qty		** I V I Reject Vumber	Rosp. Stamp
*1 A \ Packaging Packaging		Мето			0.00				120,	4	Ill	14	01/16

0.00

0.00

190

1 90

Quality Control

QC21- Final Inspection - Work Order Release

Memo

11), 1.0-16

DQA:			Date:			·							DART
QA Closed:			Date:			WORK ORDER NON-	·CC	NFOI	RMANCE / UPDATE	Wo	ork Order up	date only	AEROSPACE
						DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
Work Orde	er: _						1				. ,	_	, , , , , , , , , , , , , , , , , , ,
						Rework	ļ		Skid-tube Crosstube	-		Water Jet	Engineering
Part N	10.	. <u> </u>				Scrap			Machining Small Fab	⊢		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming Finishing	-	Rec/Stor	re/Packaging	Other
NCR N	١٥.					Suspected Unapproved			Large Fab Composite	L_		Supplier	
Root					Desci	ription of work order update	l	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre			}										
Material							ĺ						
Operator													
Offset/Setup													
Process													
Supplier													
Training											ļ		
Transport													
Unapproved					<u> </u>						<u> </u>		
y . ===				<u> </u>			FA	ULT CA	TEGORY				
Landi	ng (I			_	General		1			1	. г	¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬¬
		Bending			-	Bend	<u> </u>	4	Program	\vdash	Outside Dim	<u></u>	Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	\vdash	Grain		-	Over/Under	 	Set-up
		Cracks			<u> </u>	Broken/Damage/Defect		Hardwa		\vdash	Part Incorre	<u> </u>	Temperature/Cure Weld
		Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>		ion Incomplete/Unqualified	-	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs			-	Contamination		-	tions Incomplete/Unclear	\vdash	Part Moved	L Mrana	
	<u> </u>	Crushing			-	Countersink	\vdash	4	gned/off center	\vdash	Positioned \ Power Loss/		Other
	_	Heat Trea			<u> </u>	Cut Too Short	-	Mislab		<u> </u>	Teomer ross/	ourge [Tottlei
	_	Inspectio	•	Tube	\vdash	Drawing	-	Misrea					
	<u> </u>	Marks/Ch			-	Drill Holes	-	Off-set					
	<u> </u>	Turning S			<u> </u>	Finish		-	Calibration				
1	l	Wave/Tw	vist in Tuk	oe -		Fit/Function	1	Jout of	Sequence				

Picklist Print

September-05-14 2:25:59 PM

Work Order ID: 124026

D3492-1

Parent Item Name: Plug

124026

D3492-1

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 120.00

Required Qty: 120.00

Page 1

Comments:

Parent Item:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Oty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100		37,3545	0.0605			DAS	
*M6061T6 6061-T6 Round Bar .625"	RO 625	*				100	1	37.3343	0.0625	8		37 9-69	14.09.07

 Loc Oty
 Loc Code

 MAT012
 37.354474

 m126726
 1.854474

 m1282654
 11.5

 m129530
 24

DQA:			Date:										"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		/ork Order up	date only	AEROSPACE
Q/ (0.03cu.		 	Dute.			DISPOSITION					EPARTMENT,		
Work Orde	er:					DISPOSITION				AGAINST D		_	, <u> </u>
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	⊣	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing	│ Rec/Stor	e/Packaging	Other
NCR N	10.					Suspected Unapproved			Large Fab	Composite		Supplier	J
Root					Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		⊋^ Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design		;3-e							,				}
Doc/Data				İ		,							
Equip/Tooling													
Handling/Pre			Ì										
Material													
Operator						*							
Offset/Setup						-							
Process													
Supplier													
Training					Ì								
Transport													
Unapproved					<u> </u>		<u> </u>		<u></u>				
							FAI	ULT CA	TEGORY				
Landi	ng (1			_	General	_	1 ,		_	7	. г	7
•	<u> </u>	Bending			_	Bend	\vdash	4	Program	<u> </u> -	Outside Dim	├	Pressure/Forced
	<u> </u>	Centre N	ot Concer	ntric		BOM/Route		Grain		-	Over/Under	<u> </u>	Set-up
	_	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		11:61	Part Incorre	F-	Temperature/Cure
		Crimp/Ki	nk/Ripple	e/Wave	-	Burrs		-1	ion Incomplete/Un	F*	Part Lost/Mi	SSING	Weld
	<u> </u>	Cuffs			_	Contamination	\vdash	4	tions Incomplete/U	nciear	Part Moved	L Vrong	Wrong Stock Pulled
	<u> </u>	Crushing			<u> </u>	Countersink	\vdash	4	gned/off center	-	Positioned V Power Loss/		Other
	\vdash	Heat Trea		T l	<u> </u>	Cut Too Short	-	Mislab		L	rower Loss/	ourge [Totilei
	<u> </u>	Inspectio	-	ıupe	<u> </u>	Drawing	\vdash	Misrea Off-set					
	-	Marks/Cl			-	Drill Holes		4	Calibration			<u></u>	
		Turning S Wave/Tw			<u> </u>	Finish Fit/Function	-		Sequence				
1	1	I Anavel IN	vist iii Tül	JE		i i d Function	1	TOUT OF	Sequence				

DART AEROSPACE LTD	Work Order:	124026
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	. 0 58	/		DRIG	BUTKN
0.060	+/-0.005	.059	_		DR16	8 UEREN
Ø0.394	+/-0.010	. 3935	/		DIRIB	"B"VERED
Ø0.625	+/-0.010	.620	·-		DRIV	8 Veren
0.090	+0.000/-0.002	.089			Pin Gin	V612
0.500	+/-0.010	.500	/		DRIG	8"ULARD
0.050	+0.000/-0.002	.049	\		DR16	BLEREN
0.050 x 20°	+/-0.010	.05 > 20"	~		D216	Biren.
		-				·
			,			
			DAS			

	DAS				
Measured by:	37	Audited by:	9-89	Preliminary Approval:	
Date:	14.09.07	Date:	14/09/08	Date:	

Rev	Date	Change	Revised by Approved
Α	06.06.02	New Issue P/O D3492-041	KJ/JLM
В	06.10.16	Ø0.625 was Ø0.500	KJ/JLM
С	07.11.23	Tolerances revised	KJ/EC/DD
D	08.06.19	0.050 x 20° dimension added	KJ/DD
E	11.07.26	Dimensions updated per Dwg Rev D	KJ (A
F	14.01.21	Dwg Rev updated	KJ KJ

DQA:			Date:				*DART										
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE										
Manle Onde			DISPOSITION						Work Order update only AGAINST DEPARTMENT/PROCESS								
Work Orde	-					Rework	1		Skid-tube	Crosstube	\neg	Water Jet	Engineering				
Part N	۱o	·····				Scrap Use-as-is			Machining noforming	Small Fab Finishing		d. Eng. Coor.	Quality Other				
NCR N	۱o. ₋					Suspected Unapproved		mem	Large Fab	Composite	inec/stor	Supplier					
Root					Desc	ription of work order update		Initial	Acti	on	Sign &						
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	Description		Verification	QC Inspector				
Design																	
Doc/Data				,	7												
Equip/Tooling							Į		1								
Handling/Pre													,				
Material			1						[
Operator											,						
Offset/Setup																	
Process										£ 2 & 2							
Supplier				ļ						4	[
Training																	
Transport	П											1					
Unapproved					ĺ												
	·						FA	ULT CA	TEGORY								
Landi	ng G	iear				General		_		_		<u> </u>	_				
		Bending				Bend .		Folio/F	Program		Outside Dim	ensions	Pressure/Forced				
ı.		Centre Not Concentric				BOM/Route		Grain			Over/Under	tolerance	Set-up				
		Cracks				Broken/Damage/Defect		Hardwa	are	· ·	Part Incorre	ci	Temperature/Cure				
		Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld				
		Cuffs				Contamination		Instruc	tions Incomplete/U	nclear	Part Moved	<u></u>	Wrong Stock Pulled				
	Crushing					Countersink		Misali	gned/off center		Positioned \	Wrong	_				
	Heat Treat					Cut Too Short		Mislab	eled	Ţ	Power Loss/	'Surge	Other				
	Inspection Strip in Tube					Drawing		Misrea	d	-							
	-	Marks/Cl				Drill Holes		Off-set									
		Turning S				Finish		Out of	Calibration								
		Wave/Tw				Fit/Function		Out of	Sequence								

D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

D3492-XXX PLUG PARTS LIST

	D3492-AAA PEUG PARTS LIST													
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION					
X								D3492-041	PLUG ASSEMBLY	┪				
	Х							D3492-043	PLUG ASSEMBLY					
		Х						D3492-045	PLUG ASSEMBLY	7				
			X					D3492-047	PLUG ASSEMBLY	7				
				X				D3492-049	PLUG ASSEMBLY					
					Х			D3492-051	PLUG ASSEMBLY	1				
						Х		D3492-053	PLUG ASSEMBLY	1				
							X	D3492-055	PLUG ASSEMBLY					
1								D0400.4		7				
								D3492-1	PLUG	_				
	1							D3492-3	PLUG	_				
		1						D3492-5	PLUG	J				
			1					D3492-7	PLUG	_]]				
				1				D3492-9	PLUG					
[i			1			D3492-11	PLUG	7				
						1		D3492-13	PLUG	7				
							1	D3492-15	PLUG] <u>&</u>				
		-						NAS1611-005	O-RING	4				
			1					NAS1611-007	O-RING	-				
1								NAS1611-010	O-RING	-				
						1		NAS1611-012	O-RING	-				
	1	- +				'		NAS1611-012		4				
\rightarrow									O-RING	4				
					1		1	NAS1611-015	O-RING					
	1			1	- 1			NAS1611-016	O-RING	7				

 ${\color{red} {\rm NOTES:}}$ 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

 s_{HOp} COp_{γ} RETURNTO RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
NO 12 Y ORDER

(Y 109-0)

DELEASET 13 2013 -11- 13

D

С

REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	PH	06.01.04
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08

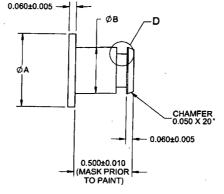
DESIGN	PH	DART AEROSPACE LTD							
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA							
CHECKED	A55	DRAWING NO.	REV. E						
MFG. APPR.	187	D3492	SHEET 1 OF 2						
APPROVED	149	TITLE	SCAL						
DE APPR.	— <i>W</i>	PLUG	NTS						
DATE 13.0	8.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THE DOCUMENT OF PRIVATE AND COMPENSAL AND IS SUPPLED ON THE COPYESS COME THAT IT IS MOT TO BE USED FOR ANY PRIMADES ON COMPENSAL OF IT OF ANY PRIMADES IN THIS INTERPRESSAL WITHOUT							

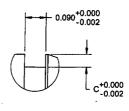
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DQA:			Date:	_									"DART			
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only										
Monte Orda				•		DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	: i : _					Powerk			Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	lo.					Rework Scrap			Machining noforming	Small Fab Finishing	Pro Rec/Sto	Quality Other				
NCR N	lo					Use-as-is Suspected Unapproved		mem	Large Fab	Composite	- Kecyston	Supplier				
Root					Desci	ription of work order update		nitial	Acti	ion	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector			
Design																
Doc/Data																
Equip/Tooling							İ									
Handling/Pre																
Material																
Operator						-										
Offset/Setup																
Process																
Supplier																
Training																
Transport			'													
Unapproved																
							FA	ULT CA	TEGORY	***						
Landir	ng G	iear				General						-	_			
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced			
		Centre Not Concentric				BOM/Route		Grain			Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	ci _	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave		Burrs	П	Inspect	ion Incomplete/Un	nqualified	Part Lost/M	issing	Weld			
		Cuffs				Contamination		Instruc	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Misali	gned/off center		Positioned \	Vrong	_			
	Heat Treat					Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other			
	Inspection Strip in Tube					Drawing		Misrea	d	_	61.		,			
		Marks/Ch	•			Drill Holes		Off-set								
·	$\overline{}$	Turning S				Finish		Out of	Calibration							
	_	Wave/Tw				Fit/Function		Out of	Sequence							

POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	С	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	┨
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	7
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	٦
D3492-11	0.850	0.664	0.045	M6061T6R0.875	7
D3492-13	0.750	0.510	0.045	M6061T6R0.750	٦
D3492-15	0.850	0.640	0.050	M6061T6R0.875	

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С

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	PH	□ DART AERO	OSPACE LTD					
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA						
CHECKED	A55	DRAWING NO.	REV. E					
MFG. APPR.	77	D3492	SHEET 2 OF					
APPROVED	10	TITLE	SCALE					
DE APPR.		PLUG	4:1					
DATE 13.0	80.80	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PREVATE AND COMPRENTIAL AND IS SUPPLED ON THE EXPRESS CONCIDENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON COMPRED ON COMMENTAL TO TO ANY OWNER PROPOSE ON THIS OWNER AND ANY ANY OWNER TO ANY OWNER PROPOSE AND ANY ANY OWNER TO.						

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DQA:			Date:						_				"DART			
						WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:					·		Wo	ork Order up	date only				
Work Orde	ar.					DISPOSITION										
WOIK OIG				, ,		Rework			Skid-tube Cr	rosstube		Water Jet	Engineering			
Part N	lo.					Scrap				mall Fab	Proc	d. Eng. Coor.	Quality			
,						Use-as-is			_ <u>}</u>	Finishing	Rec/Stor	e/Packaging	Other			
NCR N	۱o.					Suspected Unapproved			Large Fab Co	mposite 🔙		Supplier				
											· · · · · · · · · · · · · · · · · · ·					
Root					Desc	ription of work order update		nitial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector			
Design									•							
Doc/Data						·										
Equip/Tooling			1				Ì					-				
Handling/Pre																
Material																
Operator																
Offset/Setup		ļ ·	1										,			
Process		-														
Supplier					Ì											
Training Transport							1						\$.			
Unapproved	┢─		-		,		1									
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Landi	ng (Gear				General							*ue,			
	Ť	Bending				Bend		Folio/I	Program	. 1	Outside Dim	ensions	Pressure/Forced			
		Centre Not Concentric				BOM/Route		Grain			Over/Under	tolerance	Set-up			
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ાં _	Temperature/Cure			
·		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing	Weld			
		Cuffs				Contamination		Instruc	tions Incomplete/Uncle	ear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Misali	gned/off center	L	Positioned V		_			
	Heat Treat					Cut Too Short		Mislab	eled ,		Power Loss/	Surge	Other			
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	•			· · · · · · · · · · · · · · · · · · ·			
,		Marks/Cl	hatter			Drill Holes		Off-set								
		Turning S	Sequence			Finish		4	Calibration							
ļ	1	Wave/Tv	vist in Tub	рe		Fit/Function		Out of	Sequence							